

# Work Order ID 50922

July 27, 2009 7:26:39 AM



Page 1

Item ID: D3515-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Basket Lid Assembly

Start Date: 7/27/09

Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3515

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut rib D3515-1 (2) as per dwg D3516 12-Cut rib D3515-3 (2) as per dwg D3516 13-Cut rib D3515-5 (6) as per dwg D3516 14-Cut rib D3515-7 (3) as per dwg D3516 15-Cut Rib (4) D2236 from D3166-3 per dwg D2236

*SY 09/07/28*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg D3515

*SY 09/07/28*

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*PD 09-07-28*

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Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Cut expanded metal for base as per dwg D3516 2-Cut expanded metal for base ends as per dwg D3516 13-Weld expanded metal to base as per dwg D3516

8/09/07/29 (h)

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.07.30

# Work Order ID 50922

July 27, 2009 7:26:39 AM



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Item ID: D3515-041  
Revision ID: A  
Item Name: Basket Lid Assembly

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Setup Start



Stop



Start Date: 7/27/09 Start Qty: 1.00  
Required Date: 8/07/09 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	=> 8 08/08/06			(40)	4		
170  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel  Memo 1ST COAST: □ START TIME: 1:30pm □ LOVEN TEMPERATURE: 460° F □ FINISH TIME: 2:00pm ***** 2nd coat if necessary ***** 2:11pm □ 2ND COAT: □ START TIME: 2:40pm □ LOVEN TEMPERATURE: 460°	0.00  0.00	* PRESSURE WASH * 09-08-06			(40)			
180  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	=> 8 08/08/14			(40)			

# Work Order ID 50922

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Item ID: D3515-041

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Revision ID: A

Stop



Item Name: Basket Lid Assembly

Start Date: 7/27/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  HandFinish Hand Finishing	HandFinishing  Memo Wing Walk as per Dwg D3515 and QSI 005 4.4 and spray paint as per dwg wing walk: <u>m12106</u> black spray paint: <u>m1283</u>	0.00  0.00							X1 MD 09/08/10
200  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							=) 50922/14 ④ p
210  Packaging Packaging	Identify as per dwg & Stock Location: <u>PPP</u>  Memo <u>50921</u>	0.00  0.00							PC9/2/20 (U)

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Stop



Item Name: Basket Lid Assembly

Start Date: 7/27/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/24

MF 09-08-21

# Picklist Print

July 27, 2009 7:26:38 AM

Page 1

1/3

Work Order ID: 50922

Parent Item: D3515-041RevA

Parent Item Name: Basket Lid Assembly

Comments:

Start Date: 7/27/09

Required Date: 8/07/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2232-1RevC

Manufactured No

100

Each

2.0000

2.0000



Basket Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48230

B 50896

2

2

2x

SY 09/07/28

D2327-1RevD

Manufactured No

100

Each

10.0000

2.0000



Spacer Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46325

10

10

2x

SY 09/07/27

D2506RevF

Manufactured No

100

Each

6.0000

1.0000



Label Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

44275

48607

50027

6

1

1

4

1x

SY 09/07/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 27, 2009 7:26:38 AM

Work Order ID: 50922

Parent Item: D3515-041RevA

Parent Item Name: Basket Lid Assembly



Comments:

Start Date: 7/27/09

Required Date: 8/07/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	15.0000	2.0000			
												
Mounting Bracket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

23

46086

2

48428

21

D3166-3RevA1 Manufactured No

100

Each

2.8105

1.0000



Basket Hoop



2x *SY 09/07/28*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

3.747336842

50033

3.74733684

1x *SY 09/07/27*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 27, 2009 7:26:38 AM

Work Order ID: 50922

Parent Item: D3515-041RevA

Parent Item Name: Basket Lid Assembly

Comments:

Start Date: 7/27/09

Required Date: 8/07/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	482.5287	21.0526			
Expanded Metal Flat SS												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

482.5287065

108152 90  
110134 6.7  
110292 14.4  
110629 14.41  
110861 21.18  
110992 0.58  
111444 17.79  
111630 27.15  
111956 6.335517  
112147 283.983189

M304TS0.750W.065

Purchased

No

140

f

407.9338

43.6842

304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

407.9338137

111148 0.484  
111432 0.44  
111885 1.5682  
112051 0.75747369  
112263 404.68414

21.0526

SAD 09-07-27

21.0526

43.6842

SY 09/07/27

112263

3.00sf END BAR

SCRAP

July 27, 2009 7:26:38 AM

Shop Packet Print



DESIGN #	DRAWN BY #	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119) SCALE NTS	
A	06.05.05	NEW ISSUE	

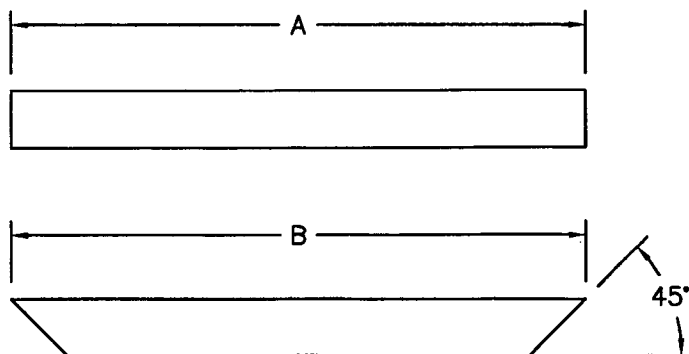
RELEASED

06.11.17 #

W/O 50922

**PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH	LENGTH	DESCRIPTION
		A	B	
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



**D3515-1/-3/-5/-7**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

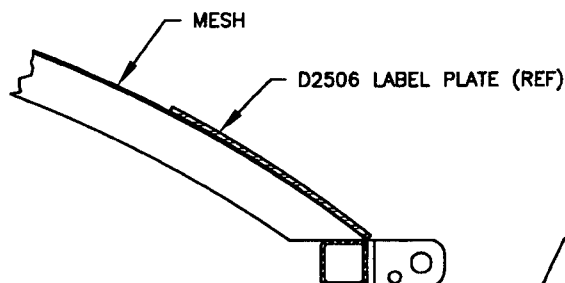
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# DART

RELEASED

06.11.07



## SECTION A-A

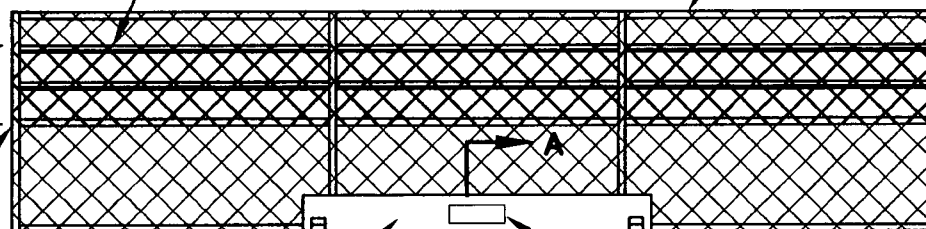
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT

TACK WELD MESH TO  
FRAME AT EVERY AVAILABLE  
LOCATION IN AREA TO BE  
ANTI SKIDDED

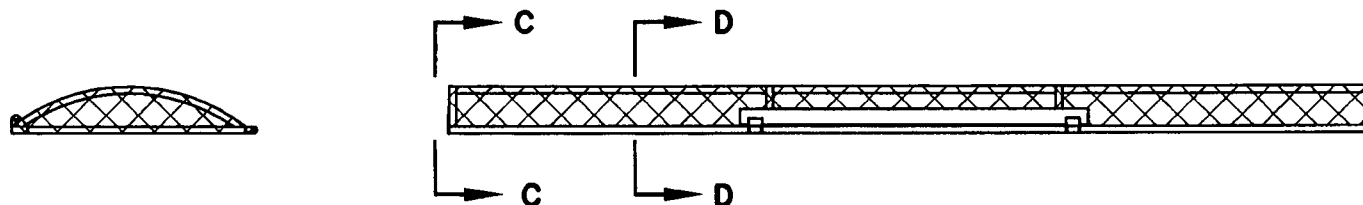
SKIN OUTSIDE SURFACE OF LID WITH  
3/4-16F EXPANDED SS. TACK WELD  
EACH END STRAND TO FRAME

SEE DETAIL B FOR  
FRAME ASSEMBLY



D2506 LABEL PLATE  
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE



## D3515-041 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

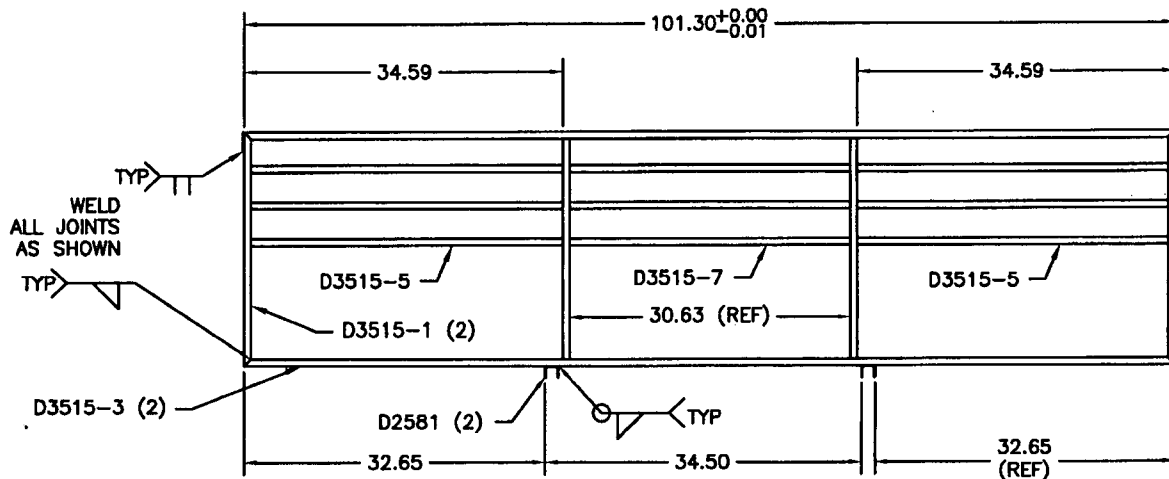
50922

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CHECKED	APPROVED	DRAWING NO. D3515	SHEET 2 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:20

HAWKESBURY, ONTARIO, CANADA

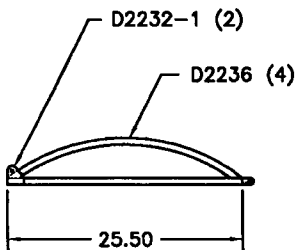
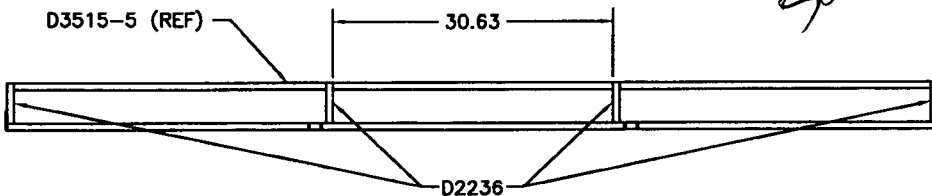
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3515	SHEET 3 OF 4
06.05.05		TITLE	SCALE
		BASKET LID ASSEMBLY (A119)	1:20



**DETAIL B**

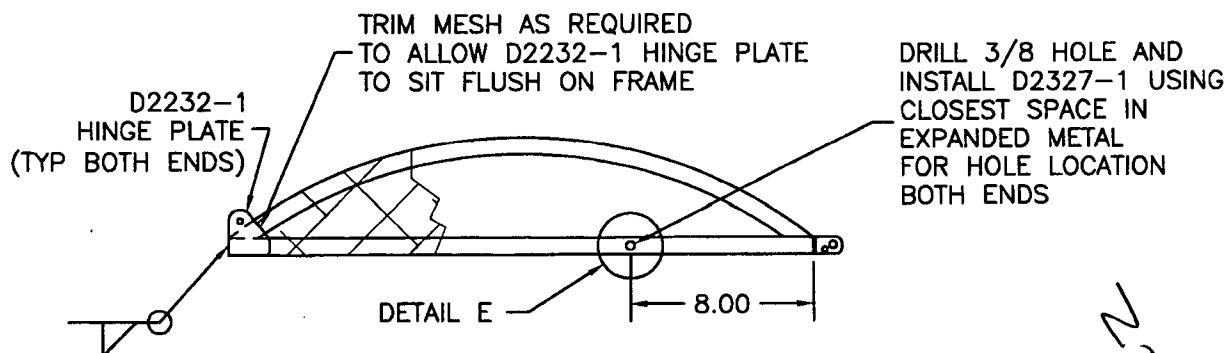
FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES



RELEASED  
06-11-17



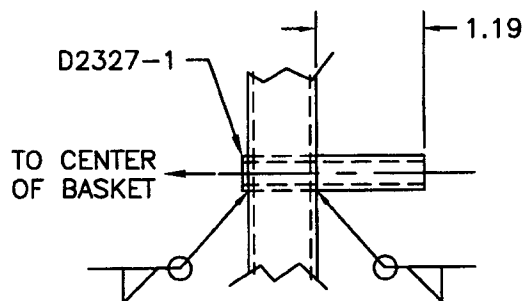
DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8



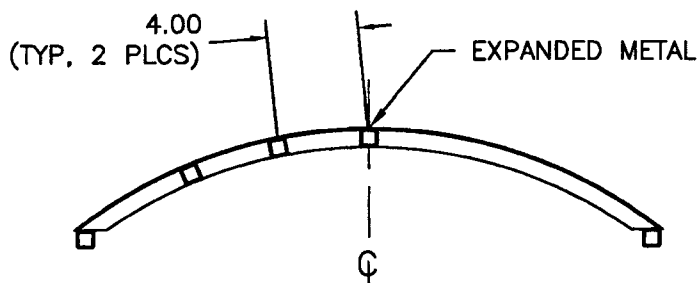
### SECTION C-C SIMILIAR BOTH END RIBS

RELEASED

06-11-17 H



### DETAIL E



### SECTION D-D SAME BOTH CENTER RIBS

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